

Date: Tuesday, 02/12/2008 10:02:15 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 02.250 SUPPORT		
Job Number	: 43880		Part Number	: D28911		
Estimate Number	: 11057		Drawing Number	: D2891 REV A1		
P.O. Number	:		Project Number	: N/A		
This Issue	: 02/12/2008	S.O. No. :	Drawing Revision	: A1		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: PURCHASED PARTS			
Previous Run	: 43383		Due Date	: 09/12/2008	Qty:	20
Written By	:		Um:	Each		
Checked & Approved By	: <u>JUL 08.12.02</u>					
Comment	: Est. C 02.11.26 Added P/O KJ Est D 08.03.19 Re-format EC verified: DD					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DSK076	D2891-1 TURNING DETAIL
Comment: Qty.: 0.5000 Each(s)/Unit Total : 10.0000 Each(s) D2891-1 TURNING DETAIL Batch: <u>B43868</u> <u>JUL 09/01/05</u>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS Machine as per Folio FA046 Tumble & Deburr <u>JUL / DTP 09/01/05</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>JUL / DTP 09/01/05</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>5/01/08</u>		
5.0	POWDER COATING	POWDER COATING <u>M109996</u> <u>20x</u>
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 START TIME: <u>10:15</u> OVEN TEMPERATURE: <u>400°</u> FINISH TIME: <u>10:45</u> <u>M-F 09/01/05</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 02/12/2008 10:02:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.250 SUPPORT

Job Number: 43880

Part Number: D28911

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



96



09-09-01

20K

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *X tube assy*

85 09-01-13

+20

8.0 QC21

FINAL INSPECTION/W/O RELEASE



09/01/14 98

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: H3880
Description: Ø2.250 Support	Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1

Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AB	0.240	0.260		0.251	0.2485	0.247	0.250	0.252
AC	0.115	0.150		0.124	0.124	0.123	0.124	0.124
AD	0.040	0.060		0.055	0.055	0.055	0.055	0.055
AE	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.295	0.295	0.295	0.295	0.295
AH	0.115	0.150		0.138	0.138	0.137	0.137	0.137
AI	0.454	0.474		0.459	0.458	0.459	0.459	0.459
AJ	2.779	2.789		2.781	2.781	2.782	2.782	2.784
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.037	1.036	1.033	1.033	1.039
AM	0.053	0.073		0.062	0.062	0.062	0.062	0.062
AN	0.257	0.262		0.262	0.262	0.262	0.262	0.262
AO	1.663	1.683		1.670	1.670	1.670	1.670	1.671
AP	0.053	0.073		0.062	0.062	0.062	0.062	0.062
AQ	0.022	0.042		0.032	0.032	0.032	0.035	0.032
AR								
AS								
AT								
Accept/Reject				✓	-	✓		

Measured by: DTP / JL Date: 09/01/05

Audited by: SL Date: 07/07/08

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	<u>JL</u>
B	08.04.21	Reformat	KJ/JLM	<u>JL</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43880
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	10
HAAS Section								
AA	0.188	0.193		.188	.188	.188	.189	.189
AB	0.240	0.260		.250	.246	.253	.245	.251
AC	0.115	0.150		.124	.125	.124	.124	.124
AD	0.040	0.060		.053	.059	.058	.054	.050
AE	0.010	0.020		.015	.015	.015	.015	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.295	.295	.295	.295	.295
AH	0.115	0.150		.137	.137	.137	.137	.137
AI	0.454	0.474		.455	.454	.454	.460	.460
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.030	1.040	1.033	1.033	1.035
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.262	.262	.262	.262	.262
AO	1.663	1.683		1.671	1.672	1.671	1.672	1.672
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: JL Date: 09/01/06

Audited by: JL Date: 09/01/06

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	JLM
B	08.04.21	Reformat	KJ/JLM	JLM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43880
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
HAAS Section								
AA	0.188	0.193		.189	.189	.189	.189	.189
AB	0.240	0.260		.252	.252	.250	.250	.252
AC	0.115	0.150		.124	.124	.124	.124	.124
AD	0.040	0.060		.048	.050	.053	.051	.050
AE	0.010	0.020		.015	.015	.015	.015	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.295	.295	.295	.295	.295
AH	0.115	0.150		.137	.137	.137	.137	.137
AI	0.454	0.474		.465	.464	.462	.463	.464
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.035	1.035	1.030	1.035	1.036
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.260	.260	.260	.260	.260
AO	1.663	1.683		1.673	1.674	1.671	1.671	1.672
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L Date: 09/01/06

Audited by: SD Date: 07/01/08

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: <u>113280</u>
Description: Ø2.250 Support	Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1

Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
HAAS Section								
AA	0.188	0.193		.189	.189	.189	.189	.189
AB	0.240	0.260		.250	.248	.250	.248	.249
AC	0.115	0.150		.125	.124	.124	.125	.125
AD	0.040	0.060		.052	.050	.048	.050	.049
AE	0.010	0.020		.015	.015	.015	.015	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.295	.295	.295	.295	.295
AH	0.115	0.150		.137	.138	.137	.138	.138
AI	0.454	0.474		.463	.462	.462	.464	.464
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.033	1.034	1.034	1.036	1.033
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.259	.259	.259	.259	.259
AO	1.663	1.683		1.672	1.673	1.672	1.674	1.675
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: JL Date: 09/01/06

Audited by: JK Date: 09/01/06

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	<u>JL</u>
B	08.04.21	Reformat	KJ/JLM	<u>JL</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

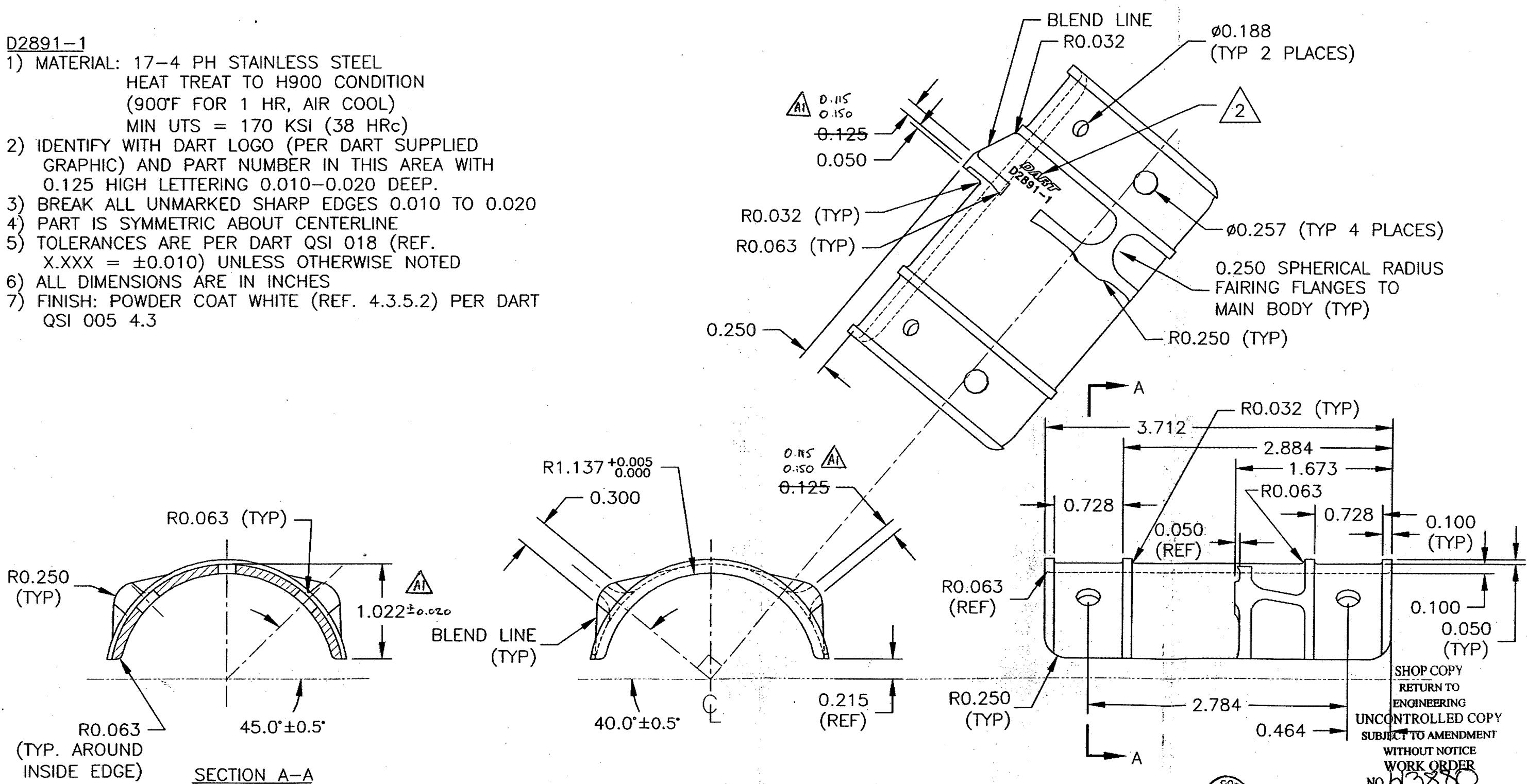
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2891-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF.
 $X_{XXX} = \pm 0.010$) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

A1	CP 02.01.23	UPDATE DIMS AS MANUFACTURED.
A	00.11.17	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	CP	APPROVED CP
DRAWING NO.	D2891	REV. A
DATE	00.11.17	TITLE Ø2.250 SUPPORT
SCALE	1:1	

